Work Order ID 70734

Tuesday, June 14, 2011 9:22:47 AM

Item ID: D2891-1 **Accept** **Setup Start**

Revision ID: ~~U/R~~ **Stop**

Item Name: 2.25 Support

Start Date: 6/14/2011 **Start Qty:** 29.00 **Cust Item ID:**

Required Date: 6/17/2011 **Req'd Qty:** 29.00 **Customer:**

Reference: REWORK

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2891	Rev A1 U/R OK								
130	~~White Gloss(Ref:4.3.5.2) per QS1003 4.3 Steel~~	0.00							
Powdercoat	**Memo**	0.00							
Powder Coating	PULL FROM STOCK: 9 X D2891-1 B53773 20 X D2891-1 B68522 STRIP PAINT COMPLETELY PER U/R FORM 11/06/13								
140	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control									

11.06.20 QS1042

11-06-17

11 06 17

Work Order ID 70734

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Item ID: D2891-1
Revision ID: U/R
Item Name: 2.25 Support

Start Date: 6/14/2011 **Start Qty:** 29.00
Required Date: 6/17/2011 **Req'd Qty:** 29.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: X tube Assy	0.00							
Packaging	**Memo**	0.00							
Packaging	RE-IDENTIFY USING NEW B/N								
160	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00							
Quality Control									

11/6/2011

MF
11-06-11

Picklist Print

Tuesday, June 14, 2011 9:22:45 AM

Work Order ID: 70734

Parent Item: D2891-1

Parent Item Name: 2.25 Support

Start Date: 6/14/2011 **Required Date:** 6/17/2011

Start Qty: 29.00 **Required Qty:** 29.00

Comments: IPP C□02.11.26□Added P/O□KJ□
IPP D 08.03.19 Re-format EC verified: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2891-1 2.25 Support		Manufactured	No				Each	0.0000		29			

B53773 x 9

B68522 x 20

~~RT~~ 11-06-17

Under Review Notification

Raised By: Chris Provencal
Date: 11.06.13

Product #: 667, 676, and 664
Product Name: crosstubes

Drawing/Kit Number	Drawing/Kit Description	Quantity on Hand (Stock)	Quantity on Order (Production)	Quantity Allocated (Customer Order)	HOLD SHIPMENT	Red Tag/Quarantine Stock	Advise customers	Stop Production	Re-Work Stock	IPP Under Review	Blue File Under Review	ECN #	Instructions
D2891-1	Support				Y	Y	N	Y	Y	Y	Y		
D2892-1	Support				Y	Y	N	Y	Y	Y	Y		
D2893-1	Support				Y	Y	N	Y	Y	Y	Y		
D2940-1	Support				Y	Y	N	Y	Y	Y	Y		
D212-664-141	Crosstube				Y	Y	N	Y	Y	Y	Y		
D412-664-145	Crosstube				Y	Y	N	Y	Y	Y	Y		
D212-664-147	Crosstube				Y	Y	N	Y	Y	Y	Y		
D212-664-241	Crosstube				Y	Y	N	Y	Y	Y	Y		
D212-664-247	Crosstube				Y	Y	N	Y	Y	Y	Y		
D206-667-141	Crosstube				Y	Y	N	Y	Y	Y	Y		
D206-667-143	Crosstube				Y	Y	N	Y	Y	Y	Y		
D407-667-145	Crosstube				Y	Y	N	Y	Y	Y	Y		
D206-667-147	Crosstube				Y	Y	N	Y	Y	Y	Y		
D206-667-241	Crosstube				Y	Y	N	Y	Y	Y	Y		
D206-667-243	Crosstube				Y	Y	N	Y	Y	Y	Y		
D206-667-247	Crosstube				Y	Y	N	Y	Y	Y	Y		
D058-676-141	Crosstube				Y	Y	N	Y	Y	Y	Y		
D058-667-241	Crosstube				Y	Y	N	Y	Y	Y	Y		

Description of issue:
- Process to bond supports onto crosstube is changing
- Finish on supports and xtube will change
- Get new process instructions from ENG prior to making more xtubes
- Modified crosstubes will need a new CHG number

Item ID	Item Name	Lot Qty	Lot Nbr
D2891-1	2.25 Support	9	53773
D2891-1	2.25 Support	20	68522
D2892-1	Support	14	42785
D2892-1	Support	14	68808
D2892-1	Support	2	70115
D2893-1	2.75 Support	15	69713
D2893-1	2.75 Support	5	69713
D2893-1	2.75 Support	1	68799
D2894-1	2.750 Support	4	66702
D2894-1	2.750 Support	4	43881
D2896-1	Support	11	67742
D2940-1	Support	20	68373
D2940-1	Support	1	60271

Chris Provencal

From: David Shepherd <dshepherd@dartaero.com>
Sent: Wednesday, June 15, 2011 3:05 PM
To: 'Chris Provencal'
Cc: 'Mike Petsche'; 'Dan Stow'; 'Eric Downing'; 'Linda Lacelle'
Subject: RE: Procedure for installing supports.

Hi Chris,

I agree with your procedure outlined below. It is our preference to leave the paint on the crosstube if we can for added corrosion protection (and for ease of manufacture). If Dan's final testing shows there is a big difference between a painted/unpainted crosstube, then we will switch to alodine only on the crosstube.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Wednesday, June 15, 2011 11:24 AM
To: 'David Shepherd'
Cc: 'Mike Petsche'; 'Dan Stow'; 'Eric Downing'
Subject: RE: Procedure for installing supports.

David,

Can I confirm that this is the agreed procedure for all newly manufactured tubes with off-center supports:

- Scuff paint under support, clean with MEK
- Completely remove any finish on support (if present), scuff bottom surface of support, clean with MEK
- Apply a 0.04" – 0.07" layer of Proseal 890 class B-2 on bottom of support and install wet.
- Install clamps and torque per dwg
- Clean up excess proseal
- Let cure for 72 hours after installation, recheck torque.

Chris

From: David Shepherd [mailto:dshepherd@dartaero.com]
Sent: Tuesday, June 14, 2011 10:59 AM
To: 'Chris Provencal'
Cc: 'Mike Petsche'; 'Dan Stow'; 'Eric Downing'
Subject: RE: Procedure for installing supports.

Made a couple of small changes.

- Remove finish on xtube in area of support down to alodine finish.
- Touch up alodine on xtube in affected area
- Completely remove any finish on support, scuff bottom surface of support
- Apply a 0.04" – 0.07" layer of Proseal 890 class B-2 on bottom of support and install wet.
- Install clamps and torque per dwg
- Clean up excess proseal
- Touch up paint finish as req'd per QSI 005
- Let cure for 72 hours after installation, recheck torque.